



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4406-041
Job Sheet 179752



Part No: D4406-041

Job Qty: 4 ea

Part Name: Fwd Wearplate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP rev A 11.06.06 new issue EC verified by:DD IPP rev B 12.02.06 as per dwg revPB1 DD
verf:EC IPP REV:C 15.11.16 AS PER PD1 DD VERF:JLM IPP REV:D 16.02.05 AS PER DWG REV.D DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		7/18/18	0.00	0.00	Start Up Large Fab-2		<i>PLC</i>
150	Large Fab	4 pcs		7/18/18	0.00	12.12	Large Fab 8		<i>PLC</i>
160	QC	4 pcs		7/18/18	0.00	0.00	QC9		<i>EL</i>
165	QC	4 pcs		7/18/18	0.00	0.00	QC5		<i>EL</i>
170	Small Fab	4 pcs		7/18/18	0.00	0.33	Small Fab-6		<i>18-08-08</i>
180	QC	4 pcs		7/18/18	0.00	0.00	QC5		<i>18-08-21</i>
190	Packaging	4 pcs		7/18/18	0.00	0.00	Packaging3-2	<i>FP-007</i>	<i>18-08-21</i>
200	QC21-SA	4 Ea		7/18/18	0.00	0.00	QC21		<i>21 AUG 21 2018</i>

Part Op 150 - 1- Weld D4407-041 to wearplate as per dwg D4406 304 S.S. Welding Rod BATCH #: *130145* 2-
Descriptions: Transfer drill holes in bar

160 - QC9- Inspect visual per QSI004- Fusion Welds
165 - QC5- Inspect part completeness to step on W/O
170 - Apply coating as per dwg D4406 *138886*
180 - QC5- Inspect part completeness to step on W/O
190 - Identify as per dwg & Stock Location *FP-007* LOCATION : FP002
200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4406-1	Plate	4 Ea (1 ea)	90-Start up Operation	<i>5097978</i>
D4407-041	Bar Weldment	8 Ea (2 ea)	90-Start up Operation	<i>5096464</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4406-1	4	6	0
	D4407-041	8	16	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																						
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																							
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																							
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																							
Large Fab ☐	Composite ☐	Supplier ☐																																																								
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																						
Description Work Order 1210 PUGHMILL STREET HAWKESBURY, ON K64 1K7 CANADA TEL: 613 832-5200 Email: sales@dartaero.com www.dartaero.com Date: 08/07/18 Container No: S099722 Part: D4406-041 Job No: 179752 Serial No/Batch: S099722 Revision: Inspector: Exp Date: Instructions: Various ST's				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																						
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width:100%;"> <tr> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td></td> <td></td> <td>☐ Part Moved</td> </tr> <tr> <td></td> <td></td> <td>☐ Drawing</td> </tr> <tr> <td></td> <td></td> <td>☐ Finish</td> </tr> <tr> <td></td> <td></td> <td>☐ Misread</td> </tr> <tr> <td></td> <td></td> <td>☐ Turning Sequence</td> </tr> </table>			☐ Cuffs	☐ Contamination	☐ Positioned Wrong	☐ Crushing	☐ Countersink	☐ Outside Dimensions	☐ Heat Treat	☐ Cut Too Short	☐ Over/Under tolerance	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Part Incorrect	☐ Marks/Chatter	☐ Drill Holes	☐ Part Lost/Missing			☐ Part Moved			☐ Drawing			☐ Finish			☐ Misread			☐ Turning Sequence
Environment ☐	No Re-verification ☐																																																									
Design ☐	Operator ☐																																																									
Doc/Data ☐	Offset/Setup ☐																																																									
Equip/Tooling ☐	Supplier ☐																																																									
Handling/Pre ☐	Training ☐																																																									
Material ☐	Use for Testing ☐																																																									
Internal Transport ☐	Poor Information ☐																																																									
Tribal Knowledge ☐	Rushing ☐																																																									
LOA ☐	Product Improvement ☐																																																									
Substation ☐	Process Improvement ☐																																																									
Past Expiry Date ☐	Manufacturing Process ☐																																																									
Misidentified ☐	Past Due ☐																																																									
☐ Cuffs	☐ Contamination	☐ Positioned Wrong																																																								
☐ Crushing	☐ Countersink	☐ Outside Dimensions																																																								
☐ Heat Treat	☐ Cut Too Short	☐ Over/Under tolerance																																																								
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Part Incorrect																																																								
☐ Marks/Chatter	☐ Drill Holes	☐ Part Lost/Missing																																																								
		☐ Part Moved																																																								
		☐ Drawing																																																								
		☐ Finish																																																								
		☐ Misread																																																								
		☐ Turning Sequence																																																								
OTHER : _____																																																										